

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006391**Date Inspected:** 07-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

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This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations after weld repair. Testing was performed in accordance with Caltrans UT procedure "Phased Array Testing for detection of planar discontinuities (cracks) in PJP welds. Results of Deck Panels evaluated are as follows:

DP417-001: 29 locations tested with 0 rejected (R1).

This QA inspector performed conventional Ultrasonic (A scan) Inspection of tack welds on deck panels. Indications located within the area of interest were marked and recorded for phased array evaluation. This QA inspector performed UT on deck panel DP390-001 (BE). The following summary below shows total of tack weld locations scanned, amount of indications and the percentage of indications for tack welds inspected on the panel.

DP390-001:

Weld 1, 26 tacks scanned with 1 indication

Weld 2, 26 tacks scanned with 2 indications

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Weld 3, 26 tacks scanned with 5 indications
Weld 4, 26 tacks scanned with 1 indication
Weld 5, 26 tacks scanned with 6 indications
Weld 6, 26 tacks scanned with 2 indications
Weld 7, 26 tacks scanned with 4 indications
Weld 8, 26 tacks scanned with 4 indications
Weld 9, 26 tacks scanned with 3 indications
Weld 10, 26 tacks scanned with 7 indications

260 tacks scanned with 35 indications (13.46%)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversations between QC and QA this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
